

\_\_\_\_\_

Thursday, March 03, 2011 9:01:52 AM

**Accept**

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**

[REDACTED]

[REDACTED]

**Customer:**

**Reference:**

Run Start



**Stop**

Operation	Description
1	Start at node A
2	Move to node B
3	Move to node C
4	Move to node D
5	Move to node E
6	Move to node F
7	Move to node G
8	Move to node H
9	Move to node I
10	Move to node J
11	Move to node K
12	Move to node L
13	Move to node M
14	Move to node N
15	Move to node O
16	Move to node P
17	Move to node Q
18	Move to node R
19	Move to node S
20	Move to node T
21	Move to node U
22	Move to node V
23	Move to node W
24	Move to node X
25	Move to node Y
26	Move to node Z
27	Move to node AA
28	Move to node AB
29	Move to node AC
30	Move to node AD
31	Move to node AE
32	Move to node AF
33	Move to node AG
34	Move to node AH
35	Move to node AI
36	Move to node AJ
37	Move to node AK
38	Move to node AL
39	Move to node AM
40	Move to node AN
41	Move to node AO
42	Move to node AP
43	Move to node AQ
44	Move to node AR
45	Move to node AS
46	Move to node AT
47	Move to node AU
48	Move to node AV
49	Move to node AW
50	Move to node AX
51	Move to node AY
52	Move to node AZ
53	Move to node BA
54	Move to node BB
55	Move to node BC
56	Move to node BD
57	Move to node BE
58	Move to node BF
59	Move to node BG
60	Move to node BH
61	Move to node BI
62	Move to node BJ
63	Move to node BK
64	Move to node BL
65	Move to node BM
66	Move to node BN
67	Move to node BO
68	Move to node BP
69	Move to node BQ
70	Move to node BR
71	Move to node BS
72	Move to node BT
73	Move to node BU
74	Move to node BV
75	Move to node BW
76	Move to node BX
77	Move to node BY
78	Move to node BZ
79	Move to node CA
80	Move to node CB
81	Move to node CC
82	Move to node CD
83	Move to node CE
84	Move to node CF
85	Move to node CG
86	Move to node CH
87	Move to node CI
88	Move to node CJ
89	Move to node CK
90	Move to node CL
91	Move to node CM
92	Move to node CN
93	Move to node CO
94	Move to node CP
95	Move to node CQ
96	Move to node CR
97	Move to node CS
98	Move to node CT
99	Move to node CU
100	Move to node CV
101	Move to node CW
102	Move to node CX
103	Move to node CY
104	Move to node CZ
105	Move to node DA
106	Move to node DB
107	Move to node DC
108	Move to node DD
109	Move to node DE
110	Move to node DF
111	Move to node DG
112	Move to node DH
113	Move to node DI
114	Move to node DJ
115	Move to node DK
116	Move to node DL
117	Move to node DM
118	Move to node DN
119	Move to node DO
120	Move to node DP
121	Move to node DQ
122	Move to node DR
123	Move to node DS
124	Move to node DT
125	Move to node DU
126	Move to node DV
127	Move to node DW
128	Move to node DX
129	Move to node DY
130	Move to node DZ
131	Move to node EA
132	Move to node EB
133	Move to node EC
134	Move to node ED
135	Move to node EE
136	Move to node EF
137	Move to node EG
138	Move to node EH
139	Move to node EI
140	Move to node EJ
141	Move to node EK
142	Move to node EL
143	Move to node EM
144	Move to node EN
145	Move to node EO
146	Move to node EP
147	Move to node EQ
148	Move to node ER
149	Move to node ES
150	Move to node ET
151	Move to node EU
152	Move to node EV
153	Move to node EW
154	Move to node EX
155	Move to node EY
156	Move to node EZ
157	Move to node FA
158	Move to node FB
159	Move to node FC
160	Move to node FD
161	Move to node FE
162	Move to node FF
163	Move to node FG
164	Move to node FH
165	Move to node FI
166	Move to node FJ
167	Move to node FK
168	Move to node FL
169	Move to node FM
170	Move to node FN
171	Move to node FO
172	Move to node FP
173	Move to node FQ
174	Move to node FR
175	Move to node FS
176	Move to node FT
177	Move to node FU
178	Move to node FV
179	Move to node FW
180	Move to node FX
181	Move to node FY

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

Accept	Qty
--------	-----

Reject  
QtyReject  
Number

**Insp.  
Stamp**

**Draw Nbr**

Revision Nbr

D2989

Rev D

0.00

0.00

0.00

0.00

0.00

0.00

## Large Fab

## Memo

1- Cut as per dwg D2989  
2- Deburr and remove identification markings on tube

QC6- Inspect dimensions to drawing

## Memo

Identify as per dwg & Stock Location: W/F

## Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66976**

Thursday, March 03, 2011 9:01:52 AM



Page 2

Item ID: D2989-19

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 3/3/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/10

CL 11/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, March 03, 2011 9:01:48 AM

Page 1

Work Order ID: 66976

Parent Item: D2989-19

Parent Item Name: Rib



Start Date: 3/3/2011

Required Date: 3/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-12-02 DD verified by:ec  
Rev:B 11.01.31 chg qc5 to 6 DD verified by:ec

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

1,309.455

2.5992

10.944



304 SQ Tube .75x.75x.065W



SAD 11-03-05

Location

Loc Qty

Loc Code

MAT

1309.4551

112398

0

116267

309.4551

116763

1000

10.944

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

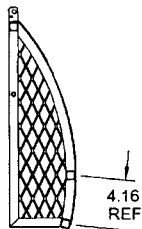
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08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.05.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED	AJS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2989</b> TITLE <b>BASKET LID ASSEMBLY</b> COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. HAS BEEN SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

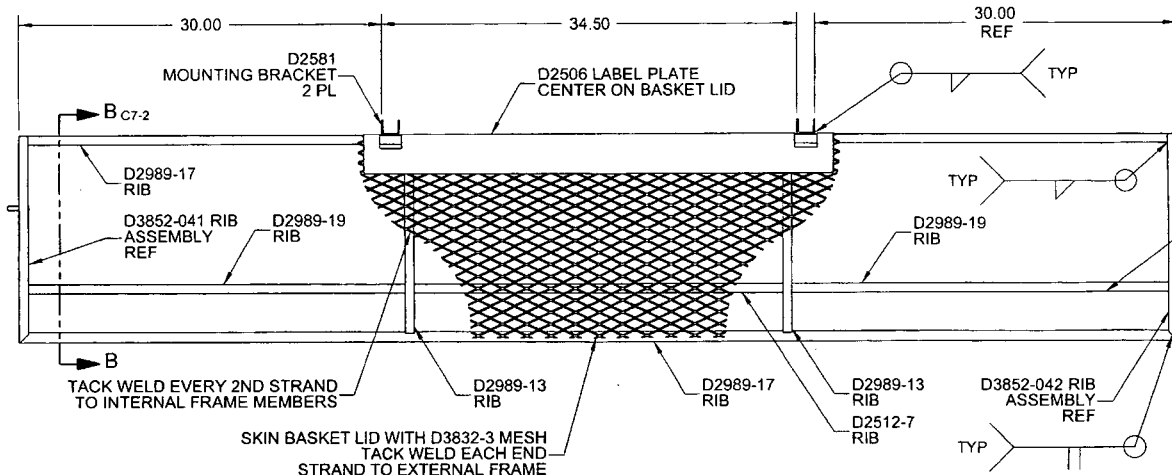
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# SECTION B-B

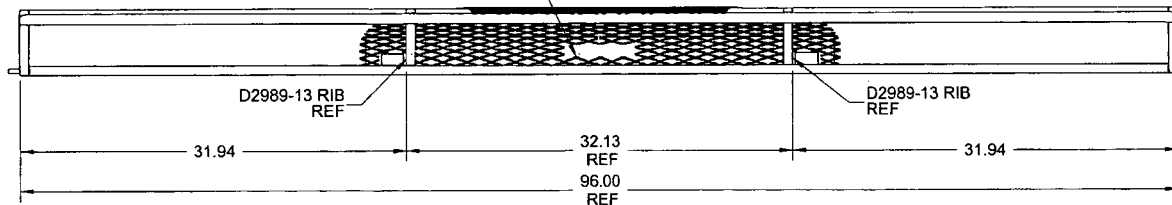
D7-2



4.16 REF



TACK WELD MESH TO LABEL PLATE AT EVERY AVAILABLE LOCATION



## D2989-041 BASKET LID ASSEMBLY (MESH SHOWN LOCALLY FOR CLARITY)



2 PL

FILL NOTCH WITH WELD 9 PL

## VIEW A:A

B8-2

W10:66976

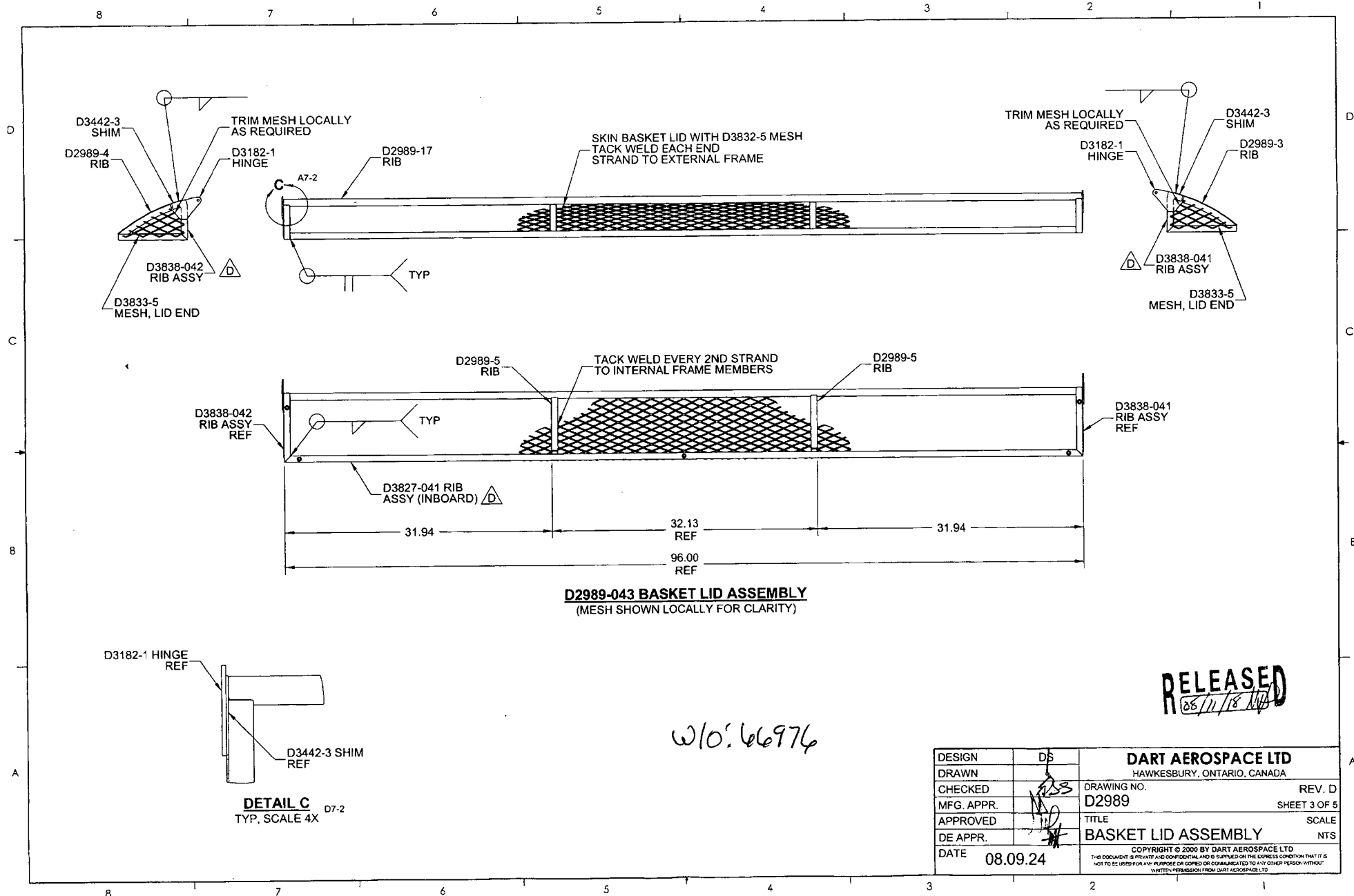
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08/11/18/17

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DRAWN	3
CHECKED	3
MFG. APPR.	3
APPROVED	3
DE APPR.	3
DATE	08.09.24

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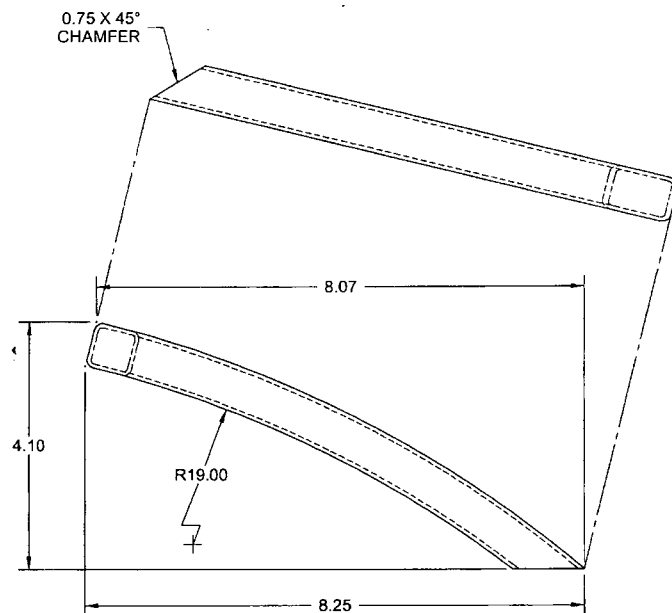
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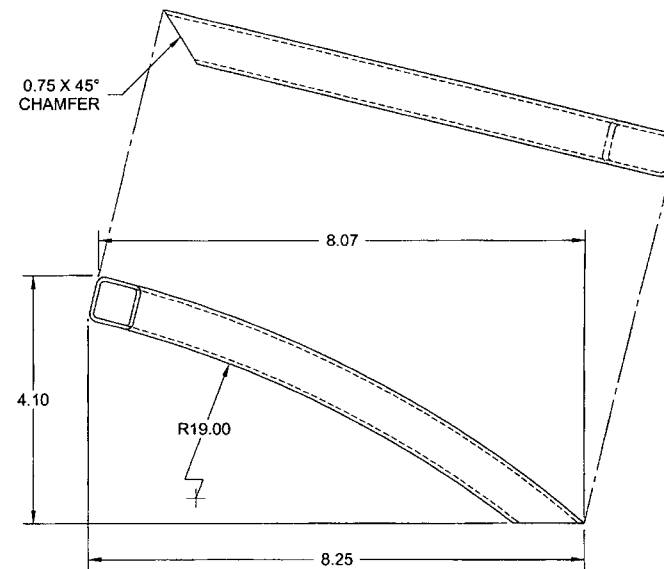


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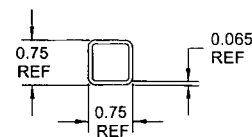
**D2989-3 RIB**



**D2989-4 RIB**

W10:66976

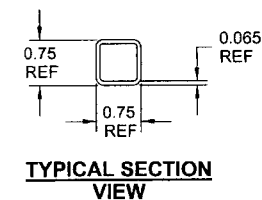
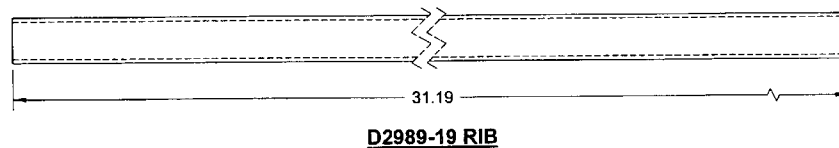
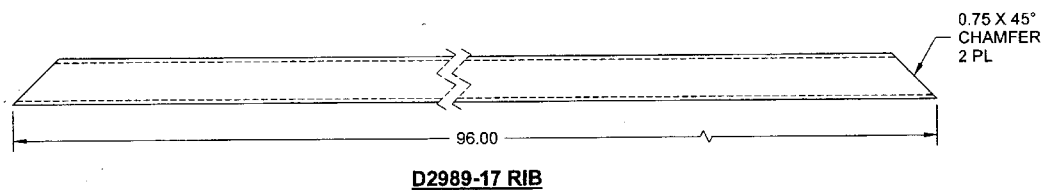
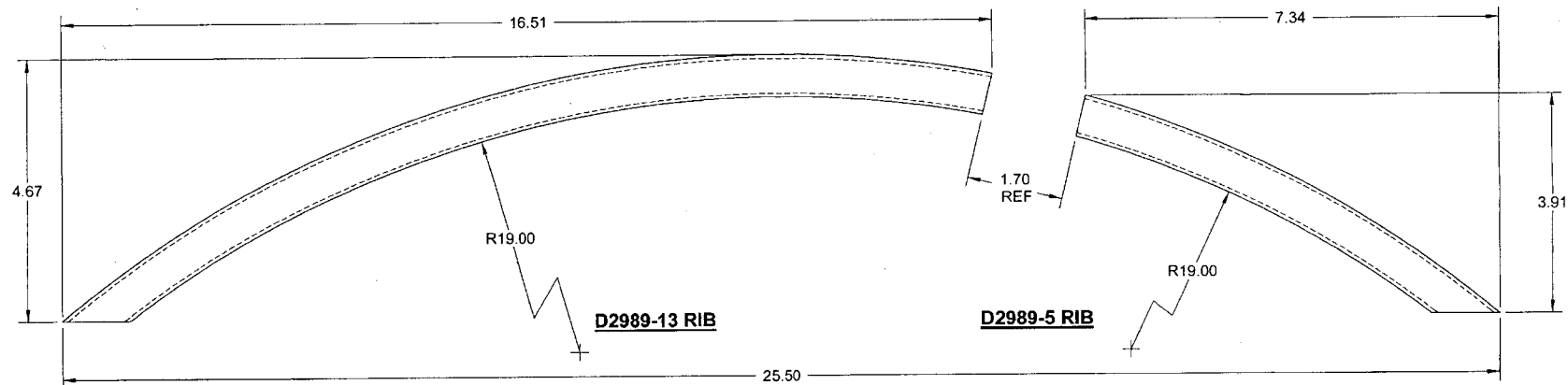
**RELEASED**  
08/11/18



**TYPICAL SECTION  
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

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WID: 66976

RELEASED  
08/11/13

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

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